

Work Order ID 79647

January-31-12 8:02:40 AM

79647

Page 1

Item ID: D205-634-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 1/31/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr:

Revision Nbr

D2580-047

(DEO) revE

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG002

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Inspect mat'l D2500-1-190 for damage
2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
3-Drill pilot holes using drill jig DT 8149 and open holes to finish size
4-Acid etch and Alodine tube per QSI 005 4.1
5- Install web as per dwg using sikaflex
A/R Sikaflex Batch #:

M119999

B79647RH

12-2-9

12-2-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT 16 2-Cut tubes as per Dwg. D2580 3- Scribe batch# in aft end of tube								
130		0.00							
130	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr ends after cutting. Remove alodine from around holes 2-Drill extra fwd hole as per DEO 9183 using drill jig DT8461 3-Drill extra middle hole as per DEO 9183 using drill jig DT8462 4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN								
140		0.00							
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

[Handwritten signature]

12-2-6

[Handwritten signature]

12-2-7

1 0 12-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 79647

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January 31-12-8 02:40 AM

Item ID: D205-634-141

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Skid tubes

Skid tubes

Skid tubes

Memo

1-Prepare tube for welding D2576-3 Step Remove alodine as required;
2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod
3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg

4- Grind cap - / DP MB2 12/02/08

160

160

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

SPC 12-02-08
M119712 8/12/02/08
12-02-7
8/21/08
8/21/08

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 1/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/09/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Pressure Wash per QSI005 4.3

0.00

180

HandFinish

Memo

0.00

Hand Finishing

And realodine tube as per QSI 005

1 of 12/02/09

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

10:40
320 F
11:10

1X of 12/02/09

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

1 of 12/02/09

W119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 79647

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RH

79647

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Item ID: D205-634-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 1/31/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Assemble as per dwg
HandFinishing

0.00

210

HandFinish

Hand Finishing.

Memo

0.00

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M119508
Sikaflex expire date: 12/08
2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594
3- Install aft cap as per dwg
4- Wing walk as per dwg Batch# M112012

IRH of M1203/08

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

8/26/10

H
RH

230

Packaging

0.00

230

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-141

Location:

PPP Rev: A

(*) SP 12-02-10

PPP 79647

W/O:		WORK ORDER CHANGES					
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Work Order ID 79647***79647***

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Item ID: D205-634-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 1/31/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/09/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/2/10
R012-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 79647
Parent Item: D205-634-141

Start Date: 1/31/12

Required Date: 2/09/12

Parent Item Name: Replacement Skidtube

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 11.09.14 new issue EC verified by:DD
ECN11-684 DD VERF:EC IPP REV:B 12.01.23 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-45A Bolt		Purchased	No			210	Each	96.0000	8	8		12/02/09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350A		96							
				118926		96							
D2500-1-190 Ext'n -1' Beam Tube 4"		Manufactured	No			110	Each	60.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		60							
				74777		60							
D2570 Bushing		Manufactured	No			210	Each	607.0000	16	16		12/02/09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST011		607							
				72960		41							
				78585		166							
				78586		200							
				78587		200							
D2596 Web, 205 Skidtube		Manufactured	No			110	Each	0.0000	1	1		12-2-3	
D4202-1 Spacer		Manufactured	No			150	Each	960.0000	1	1		12-2-3	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		446							
				77727		123							
				77729		323							
				LG002		514							
				78806		514							

① 12-2-3
20 24 20 24
12-02-07
② 12-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 79647

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

D4406-041 Manufactured No 210 Each 1.0000 1 378116 1 (x1) M 12/02/09
Fwd Wearplate Assembly

Location	Loc Qty	Loc Code
FP002	1	
74147	1	

D4406-043 Manufactured No 210 Each 1.0000 1 379406 (x1) M 12/02/09
Aft Wearplate Assembly ✓

Location	Loc Qty	Loc Code
FP001	1	
74149	1	

MS21042-4 Purchased No 210 Each 1,248.0000 8 1119075 (x8) M 12/02/09
USE MS21042L4 *

Location	Loc Qty	Loc Code
ST299	1248	
100743	9	
119124	1000	
5389	66	
5461	3	
6844	19	
7690	24	
8182	115	
9063	8	
9229	4	

D2576-3 Manufactured No 150 Each 81.0000 1 1 BE 12/02/08
Step (maching detail)

Location	Loc Qty	Loc Code
LG	81	
70883	31	
74136	50	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 3

Work Order ID: 79647

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 1/31/12

Required Date: 2/09/12

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 210 Each 80.0000

Cap

1 12/02/09

Location	Loc Qty	Loc Code
FP002	80	
65519	2	
73347	30	
<u>75074</u>	48	

AN3-5A Purchased No 210 Each 1,254.0000

Bolt

2 12/02/09

Location	Loc Qty	Loc Code
ST350	1254	
115371	46	
117423	210	
<u>118626</u>	298	
119355	200	
120187	500	

AN960JD10L NAS1149D0332J Purchased No 210 Each 0.0000

Washer

2 11/19/12 12/02/09

D2594-3 Manufactured No 210 Each 296.0000

O-Ring, 205 Skidtube

8 12/02/09

Location	Loc Qty	Loc Code
FP001	296	
65518	41	
<u>73490</u>	255	

D2594-1 Manufactured No 210 Each 562.0000

Plug, 205 Skidtube

8 12/02/09

Location	Loc Qty	Loc Code
FP001	562	
73401	30	
74442	34	
74869	184	
76075	64	
<u>77035</u>	250	

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Shop Packet Print

Page 3

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LIST OF MATERIALS					DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DEO ATTACHED

RELEASED
2011-08-29

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D2580	SHEET 1 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

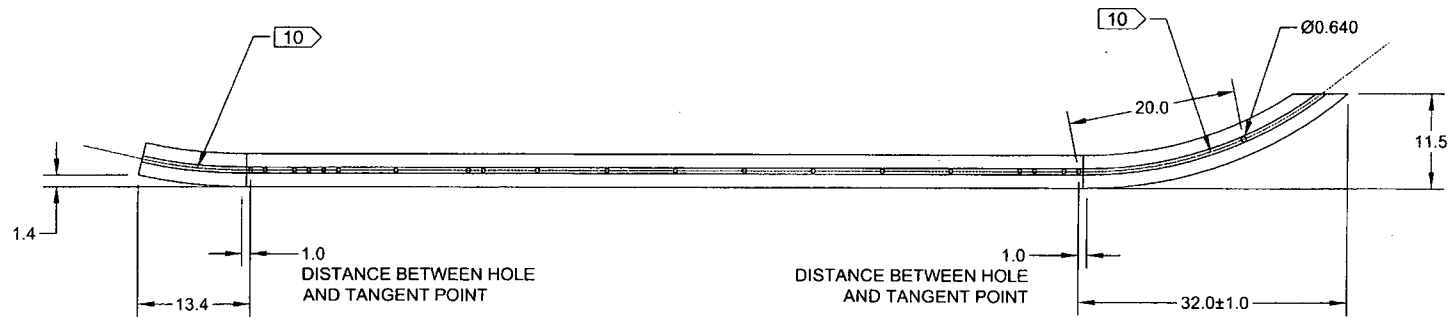
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NOTE: Date & initial all entries



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED

RELEASED
2011-08-28
JW

DESIGN	<i>RF</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>RF</i>	D2580	SHEET 3 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	11.06.21	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

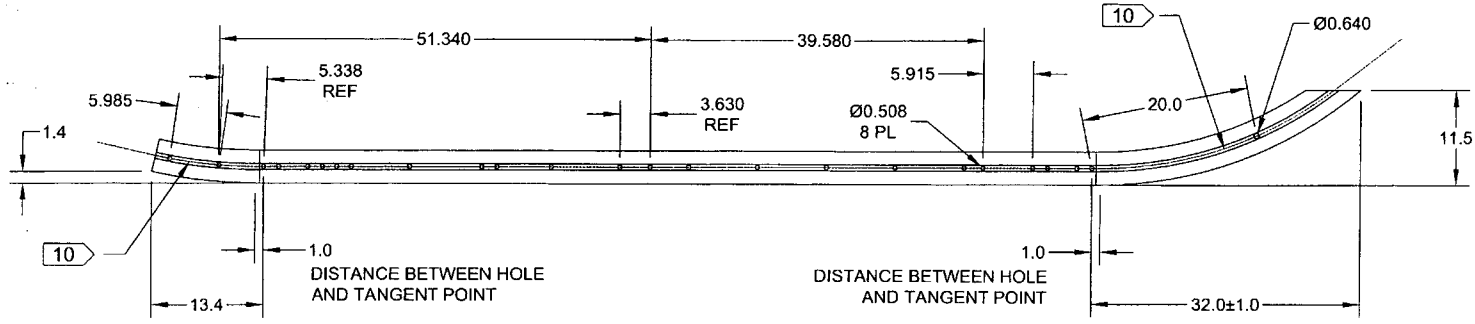
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

DEO ATTACHED
RELEASED
2011-08-29
ND

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. E
MFG. APPR.	140	D2580	SHEET 5 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	205 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

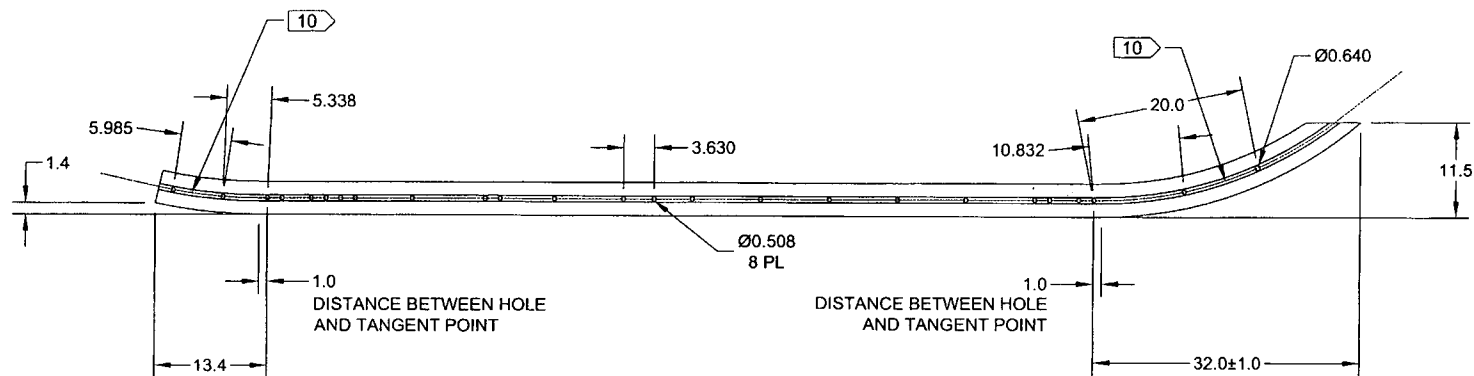
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)



DEO ATTACHED
RELEASED
2011-08-29
AM

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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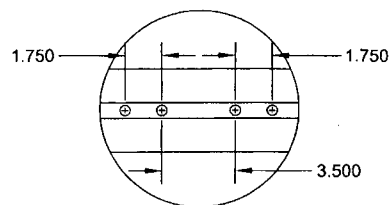
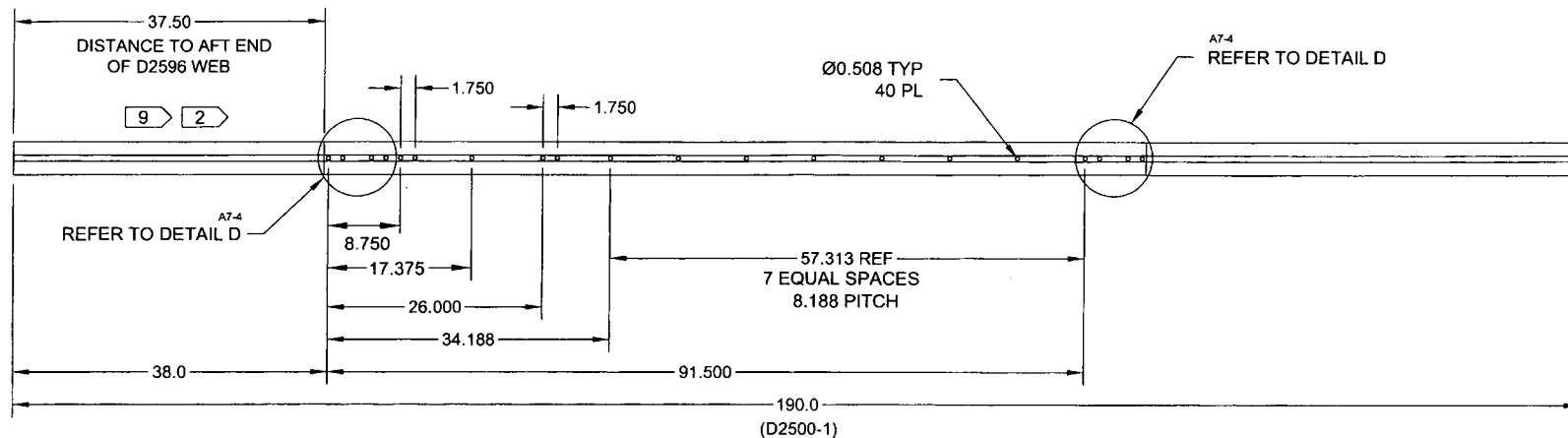
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL D 03-4
SCALE 5X C7-4

D2580-101 TUBE

DEO ATTACHED
RELEASED
R 2011-08-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 8 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D2580-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>ER</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13	DATE 11.12.13		

PURPOSE:

CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

WAS

QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045	-047		
20	24	25	D2579	CROSS BOLT SPACER

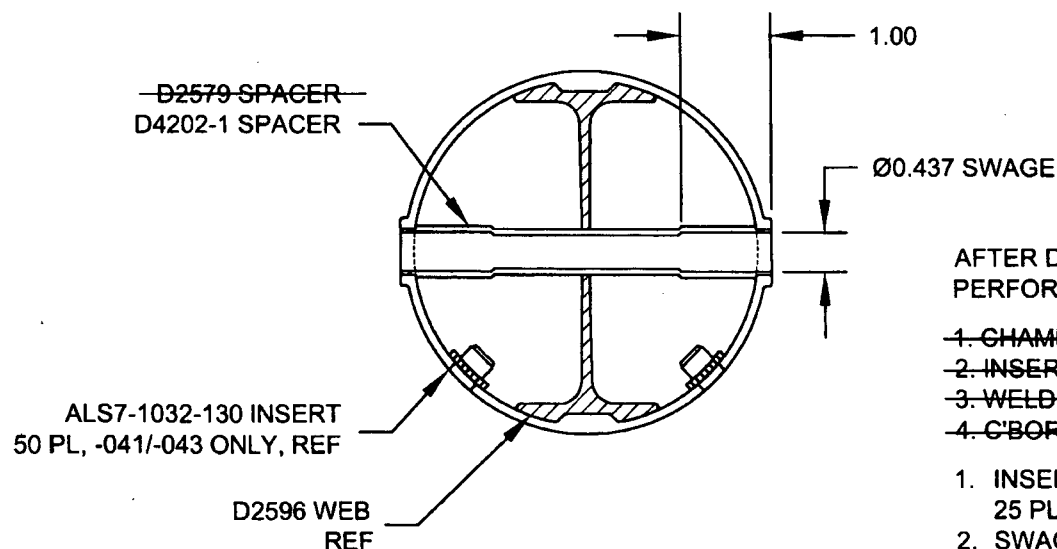
IS

	4		* D2579	CROSS BOLT SPACER
20	20	25	D4202-1	SPACER

SECTION B-B, SECTION F-F, & SECTION I-I ARE AMENDED AS FOLLOWS
FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:

*** FOR -045 SKIDTUBE ONLY:**

WELD 4X D2579 SPACERS PER DWG
IN LOCATIONS MARKED "NO C'BORE".
REF SHEET 4 OF DWG.



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- ~~1. CHAMFER HOLE 0.050 X 45°~~
- ~~2. INSERT D2579 SPACER (20 PLACES)~~
- ~~3. WELD INTO PLACE AND GRIND FLUSH~~
- ~~4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP~~

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 20 PL (-045) OR 25 PL (-047)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B, F-F, I-I
NOT TO SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries